

Work Order ID 98779

March-25-13 9:59:50 AM

98779

Page 1

Item ID: D119-646-212 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Skidtube STD w/ Training Wearplates, RH
 Start Date: 3/25/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/25/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference: RA111502 - REWORK ECN13-534

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-646-212
CHG004

0.00

0.00

102

102

HandFinish

Hand Finishing

Memo

PULL FROM RA111502
1 X D119-646-212 B91624 CHG003
REMOVE FWD CAP, PUT ASIDE TO RE-INSTALL

0.00

0.00

104

104

Skidtubes

Skidtubes

Memo

COUNTERSINK FWD MOST HOLES TO 0.385 X 100DEG ON BOTH SIDES
PER DS-109
DEBU

0.00

0.00

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT. CANADA K6A 4K7		TE APPROVAL #09-39 TEL: 1-816-682-5200	
P/N	D119-646-212	CHG	CHG003
DESC.	Skidtube STD, RH	STC	SR02024SE
LOT	B91624	STC	
MODEL	Agusta A119/AW119MKII	STC	
PATENTS: US #5735464, CA #2222185 EUROPEAN NO. #0828655		MADE IN CANADA 02729-2	

B98779 RH

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 16	13/03/28					
106 *106* HandFinish Hand Finishing	Memo -RE-ALODINE AFFECTED AREAS -TOUCH UP WITH IMRON	0.00 0.00				120	f	13/04/28	
107 *107* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	DAS 16	13/03/28					

P

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98779

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
108 *108* HandFinish Hand Finishing	Memo REPLACE FWD CAP USING MS24694-C52 SCREWS SIKAFLEX B <u>M12344</u>	0.00 0.00				<u>1 RH</u>	<u>d</u>	<u>ll</u>	<u>13/03/28</u>
109 *109* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
110 *110* Packaging Packaging	Pick Kit Memo ENSURE ORIGINAL KIT IS IN BOX	0.00 0.00							

Work Order ID 98779

98779

Page 4

March-25-13 9:59:50 AM

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 Required Date: 3/25/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference: RA111502 - REWORK ECN13-534

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		SM		1			
130 *130* Packaging Packaging	REPACKAGE USING NEW B/N NEW LABELS AND DSI PAPERWORK REQ'D Identify and pack for shipping as per PPP D119-646-212 Location: _____ PPP rev: _____	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							



13/4/13

13/4/13

11-04-13

March-25-13 9:59:50 AM

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.12 as per ECN12-644 DD verf:JLM IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to chg004 (ECN 13-534) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-212		Manufactured	No				Each	0.0000		1	B91624		
Skidtube STD w/ Training Wearplates, RH													
MS24694-C52		Purchased	No				Each	182.0000		2	13103126		
Screw													
				<u>Location</u>				<u>Loc Qty</u>					
				ST301				182					
				124291				82					
				124308				100					

PA 11502

Returned D119 skids for reworking

D119-646-212

Batch # B91624

CHG # 003

08279

☐ yes ☐ no

☐ ☒ X

Was the box the skid tube returned in damaged
if yes describ

☐ ☒ X

Was the skid tube damaged?
What was damaged

☐ ☒ X

Does it need to be repair and replaced

☒ RH ☐

Is the tube the correct part (LH/RH)

☒ X ☐

Is the "k" kit returned with the skid tube
if yes B# 91624 CHG003

☐ ☒ X
☒ X ☐

Was the kit opened
Was it re verified

☒ X ☐
☒ X ☐

Test fit Saddles caerfully. Fwd & Aft
Do the Fit

WHAT RE WORK DO THEY NEED

☒ X ☐

Do the need Fwd cap holes counter sunk

☐ ☒ X

Do the need the extra ground handling holes installed

☐ ☒ X

Do they need Both

Inspected By _____
Date _____

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with $\varnothing 0.500"$ (12.7 mm drill), and countersunk to $\varnothing 0.650 \times 100^\circ$, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to $\varnothing 0.385 \times 100^\circ$.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the $\varnothing 0.500$ holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
- 2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER
4	MS24694-C52	SCREW

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

B	ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS	DB	13.02.20
A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD GROUND HANDLING SPACER KIT	NTS
DATE	13.02.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

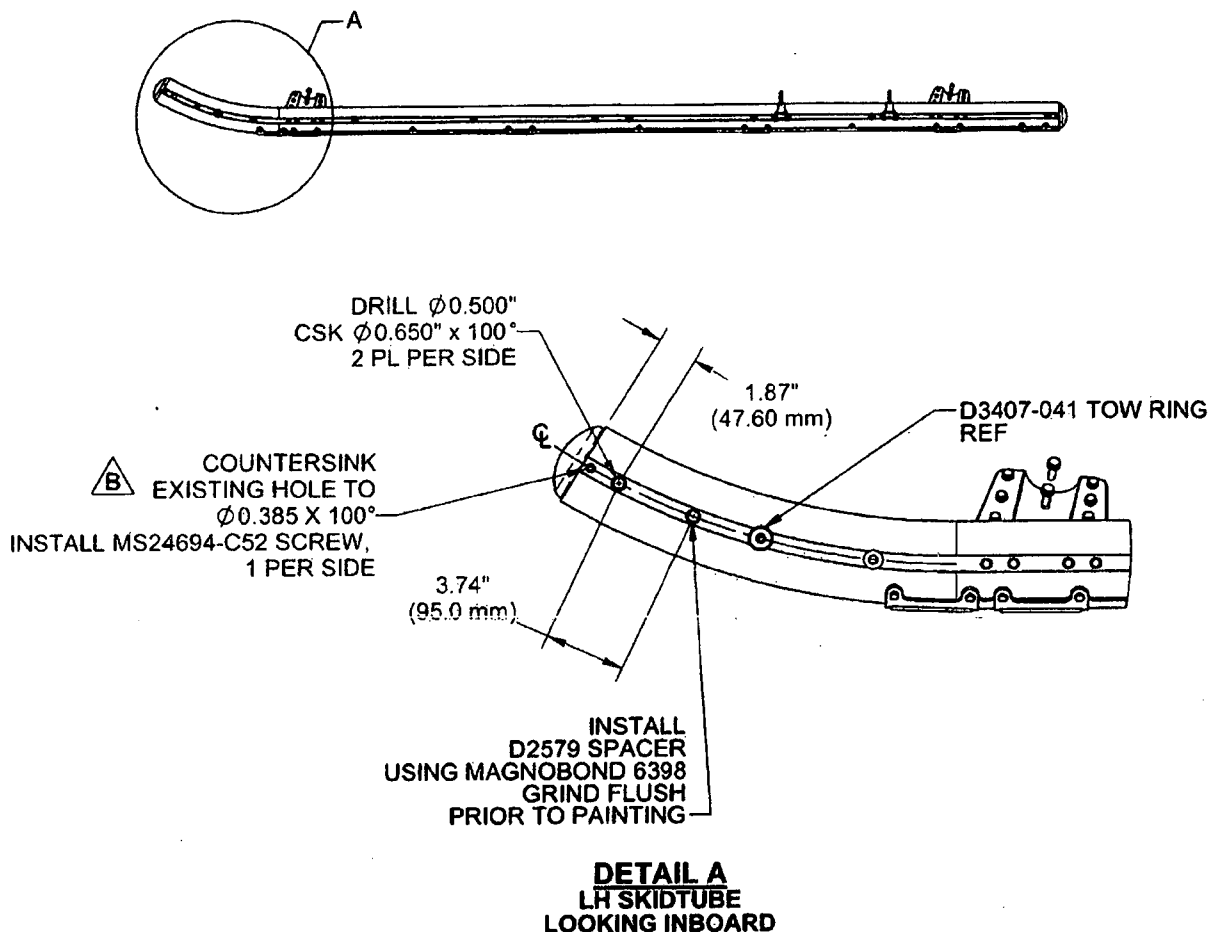


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

DESIGN	RF	DART AEROSPACE USA, INC	
DRAWN	DB	KENT, WA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9594	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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Linda Lacelle

RAU502

From: Eric Downing
Sent: March-22-13 3:50 PM
To: Linda Lacelle; Melanie Fauteux; Cathy Kerr
Cc: Patrick Smith; Sian Willems; Marc Bellavance; Lisa McMachen; Nigel Forbes
Subject: Returned D119 skids
Attachments: Check Sheet For retruned D119 skids B74791.xlsx; Check Sheet For retruned D119 skids B74793.xlsx; Check Sheet For retruned D119 skids B91588.xlsx; Check Sheet For retruned D119 skids B91559.xlsx; Check Sheet For retruned D119 skids B91623.xlsx; Check Sheet For retruned D119 skids B91624.xlsx

Linda / Mel

Work Scheme for the returned D119 skids from Agusta

- On 4 tubes the fwd. cap will need to be reworked as per the DSI
 - Remove and scrap both An3C-5A bolts and washers
 - Counter sink hole as per DSI
 - Touch up alodine as per QSI005
 - Touch up powder coat as per QSI005 with imron paint
 - Install screw per DSI
- On tubes with B74791 & B74793 this work is required
 - Remove all hard wear
 - Both end caps and all wear plates
 - Strip entire tube as per QSI 005
 - Locate both FWD holes as per DSI & ECN Drill as per drawing
 - Install cross bolt spacers as per DSI
 - Weld as per QSI004 A/R _____
 - Buff welds and deburr
 - Counter sink FWD end cap holes
 - Re alodine tube as per QSI 005
 - Re powder coat tube as per QSI005
 - Re wing-wak as per QSI005
 - Re assemble as per Drawing and per DSI

98774
98775
98776
98777
98778
98779

Thanks

Eric Downing

QC Corrdinator

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F: 1-613-632-5246

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Edowning@Dartaero.com